

Date: Thursday, 3/13/2008 10:20:06 AM  
 User: Kim Johnston

## Process Sheet

SPLIT -1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG ASSEMBLY		
Job Number	: 37928 -1						
Estimate Number	: 10012						
P.O. Number	:			Part Number	: D27363		
This Issue	: 3/13/2008	S.O. No.	:	Drawing Number	: D2736 REVA		
Prsh Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: LARGE FAB ASSY	Drawing Revision	: A		
Previous Run	: 37154			Material	:		
Written By	:			Due Date	: 4/10/2008	Qty:	13
Checked & Approved By	:				40	Um:	Each
Comment	: Est Rev 0	Removed from 9 digit	05-10-25 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2591	Lug	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)		
	Pick:		
	Qty	Part Number	Description
	1	D2591	Lug
			Batch B256059 → 4X
			B33568 → 9X
			SP 08-04-03
2.0	D27353	Lug Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)		
	Pick:		
	Qty	Part Number	Description
	1	D2735-3	Lug Bracket
			Batch B37439 → 13X
			SP 08-04-03.
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1		
	Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484		
	Steel Rod Batch: M105138		SP 08-04-03.
4.0	QC9	VISUAL WELDING INSPECTION	
	Comment: VISUAL WELDING INSPECTION		PD 08-04-04 (13)
5.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP		5 08-04-04 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 37928

Part Number: D27363

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M 107550



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

BL. 08/04/07.

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/04/07

(13)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 471A

8/4/1

500

(13Y)

9.0 QC21

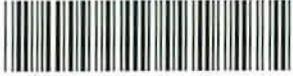
FINAL INSPECTION/W/O RELEASE



08/04/08/J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

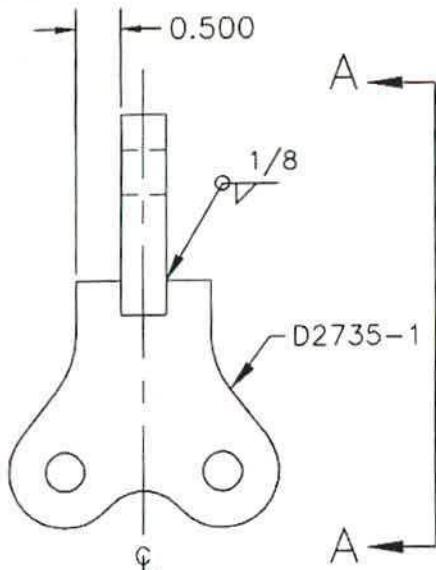
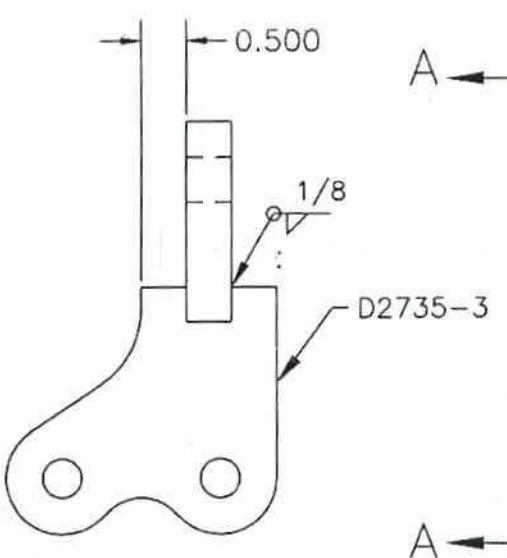
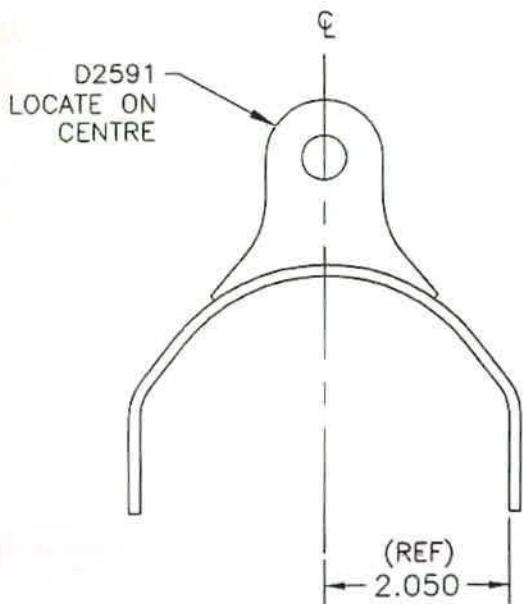
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DS</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A 97.12.18		NEW ISSUE	

D2736-1 LUG ASSEMBLYD2736-3 LUG ASSEMBLYVIEW A-ANOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

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WITHOUT NOTICE  
NO. 37928

RELEASED  
97/12/24 DS

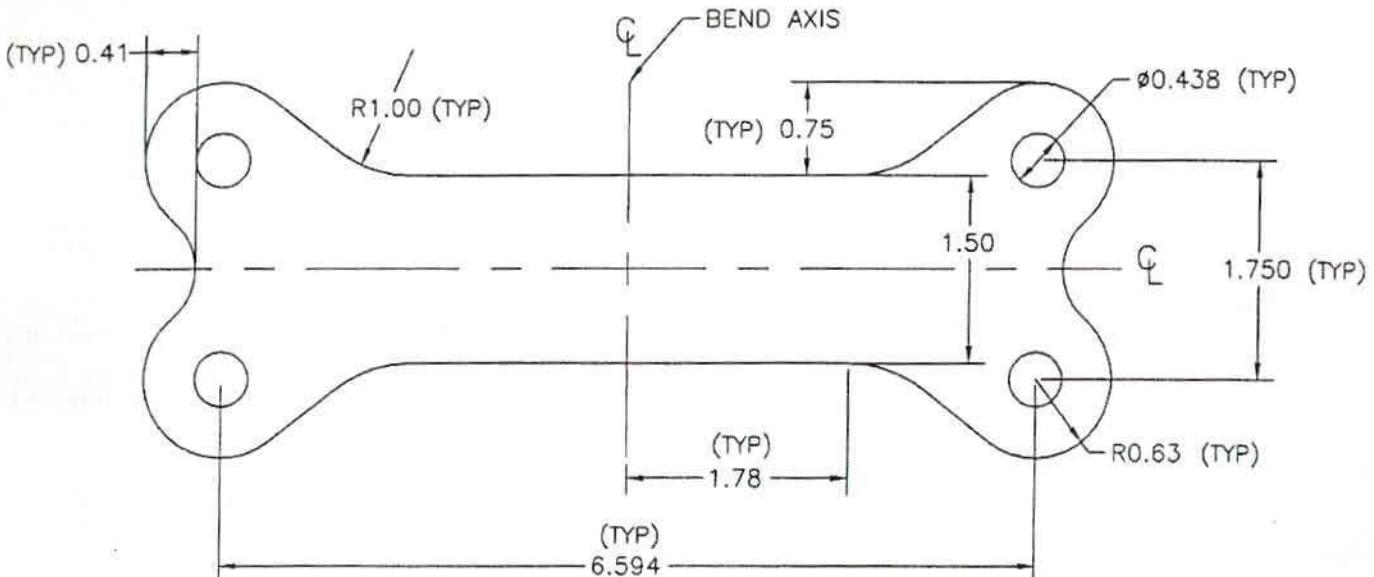
ECN 057

**DART**

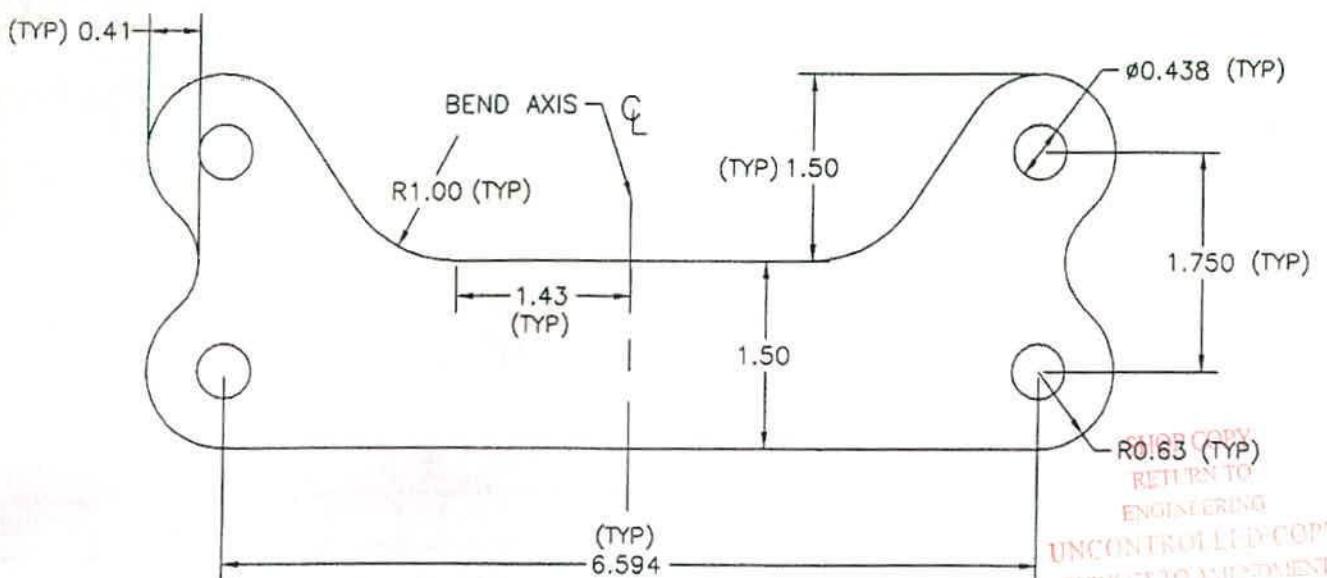
10 COPY ISSUED

DESIGNER	DRAWN BY	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA
CHECKED	AP	APPROVED
		REV. C
		D2735
DATE		TITLE
98.12.14		LUG BRACKET
		SCALE
		2:3
A	97.12.14	NEW ISSUE
B	98.10.23	UPDATE MATERIAL (TSR A1114)
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)

**RELEASED**  
98.12.14 DS



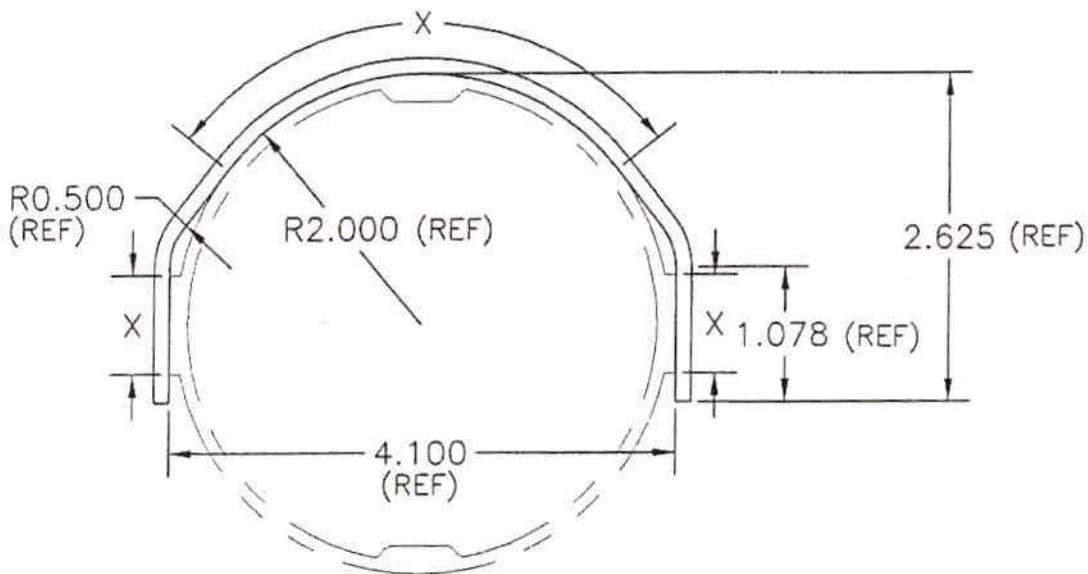
D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)



D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE (C)

**DART**

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

**RELEASED**  
18.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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